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S000725

D350-591-311
Job Sheet 165855



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D350-591-311 Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible	DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC		0.000	
AN3-35A Bolt			0.000	
AN4-13A Bolt			0.000	
AN5-36A Bolt			0.000	
D2230-3 Mounting Lug	DWG REV G IPP D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC		0.000	
D2618 Bushing	DWG REV B1 IPP Rev:F Re-format 05-11-22 JLM		0.000	
D2856-400-720 Abrasion Strip 4" X 7.20"	DWG REV A IPP Rev:A 10.11.02 as per revA DD verf:EC		0.000	
D3065-041 Step Leg Assembly	DWG REV B IPP Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF		0.000	
D3066-1 Spacer	DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3219-1 Plate	DWG REV B IPP A 04.04.19 New issue KJ/JLM ESP B 06 05 25 Waterjet EC		0.000	
D3235-1 Mounting Lug	DWG REV A IPP A 04.04.19 New issue K.			
D3272-1 Step	DWG REV B IPP Rev:A New Issue 07-06-0			
D3278-041 Support Assembly	DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP rivet per PAR185 EC Verified by: JLM			
MS20600-AD4W4 Rivet				
MS21042L3 Nut	DWG REV A			

Status: Stock

Part: D350-591-311 B165855

Created: 9/30/17 12:37 PM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: S000149

Printed By: Goldston, Justin 10/2/17 10:45 AM

Plex 10/1/17 1:45 PM Dart.Renwick.Jennifer

B#165855x8

MS21042L4
Nut
MS21042L5
Nut
NAS1149D0363J
Washer
NAS1149D0463J
Washer
NAS1149D0563J
Washer

0.000
0.000
0.000
0.000
0.000

Job Routing

Op	No	Operation	Qty	Due Date	Setup		Workcenter / Supplier	Lead Time
					Standard	Run		
90		Start up Operation	10 Ea	10/27/17	0.00	0.00	Start up container	
100		DC	10 pcs	10/27/17	0.00	0.00	DC	
180		Large Fab	10 pcs	10/30/17	0.00	10.00	Large Fab 2	
250		Packaging	10 pcs	10/31/17	0.00	0.00	Packaging1	
260		QC	10 pcs	10/31/17	0.00	0.00	QC4	
270		Packaging	10 pcs	10/31/17	0.00	0.00	Packaging3	
280		QC21-FG	10 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Descriptions: 180 - 1-Assemble Leg Assembly as per Dwg D3272.

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D350-591-311 B165855	Bolt	100 Ea (10 ea)	90-Start up Operation	
AN4-13A		80 Ea (8 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D350-591-311 B165855	100	10	0	0
250-Packaging	AN4-13A	80		0	0

Part Specifications

Specifications could not be found.

Work Order Summary

Thursday, September 28, 2017 8:54:37 AM

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Criteria : Work Order ID: 165855 Item ID: D350-591-311 Product Family LARGE FAB
Work Order Start Dates 9/1/2017 to 9/1/2017 11:59:59 PM Work Order Required Dates 9/25/2017 to
9/25/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID 165855 Required Qty 10.0000 Status Code Released
Item ID D350-591-311 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Current Acct Value \$703.537

Start Date	9/1/2017	Required Date	9/25/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$1,486.624	\$0.000	\$147.129	\$147.129	100.00%
Labor	\$1,607.415	\$0.000	\$156.072	\$156.072	100.00%
Outplant	\$0.011	\$0.000	\$0.003	\$0.003	100.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$3,708.246	\$0.000	\$357.375	\$357.375	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$6,802.297	\$0.000	\$660.578	\$660.578	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
AN3-35A Bolt	20.0000		9/25/2017	20.0000	\$9.400
AN5-36A Bolt	20.0000		9/25/2017	20.0000	\$17.400
D2230-3 Mounting Lug	40.0000		9/25/2017	40.0000	\$456.156
D2618 Bushing	20.0000		9/25/2017	20.0000	\$298.348
D2856-400-720 Abrasion Strip 4" X 7.20"	20.0000		9/25/2017	20.0000	\$111.946
D3065-041 Step Leg Assembly	10.0000		9/14/2017	10.0000	\$720.818
D3066-1 Spacer	20.0000		9/14/2017	20.0000	\$87.086
D3067-1 End Plate	10.0000		9/25/2017	6.0000	\$15.184
	10.0000		9/8/2017	4.0000	\$8.412
	10.0000		9/14/2017	10.0000	\$21.386
D3219-1 Plate	20.0000		9/8/2017	20.0000	\$169.240
D3235-1 Mounting Lug					

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Work Order Summary

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D3272-1	20.0000	9/25/2017	20.0000	\$231.590
Step				
D3278-041	10.0000	9/25/2017	10.0000	\$528.239
Support Assembly				
MS20600-AD4W4	10.0000	9/25/2017	10.0000	\$932.260
Rivet				
MS21042L3	160.0000	9/14/2017	160.0000	\$28.800
Nut				
MS21042L4	20.0000	9/25/2017	20.0000	\$2.800
Nut				
MS21042L5	80.0000	9/25/2017	80.0000	\$13.592
Nut				
NAS1149D0363J	20.0000	9/25/2017	20.0000	\$6.400
Washer				
NAS1149D0463J	40.0000	9/25/2017	40.0000	\$0.800
Washer				
NAS1149D0563J	160.0000	9/25/2017	160.0000	\$4.624
Washer				
	40.0000	9/22/2017	40.0000	\$1.200
			Total Matl Amts:	\$3,665.681

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUD01												
9/26/2017												
230			0.00	0.00	5.59	5.59	1.00	\$0.000	\$121.966	\$304.439	\$0.000	\$426.405
LECO02												
9/14/2017												
140			0.00	0.00	2.60	2.60	1.00	\$0.000	\$56.706	\$141.544	\$0.000	\$198.250
9/19/2017												
210			0.00	0.00	0.49	0.24	2.00	\$0.000	\$5.335	\$13.316	\$0.000	\$18.651
Total:			0.00	0.00	8.68	8.44	4.00	\$0.000	\$184.007	\$459.299	\$0.000	\$643.306

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
lu01												
9/8/2017												

110		0.00	0.00	4.84	4.84	1.00	\$0.000	\$103.959	\$211.013	\$0.000	\$314.972
	9/11/2017										
110		0.00	0.00	4.94	4.94	1.00	\$0.000	\$106.115	\$215.390	\$0.000	\$321.505
110		0.00	0.00	3.87	3.87	1.00	\$0.000	\$83.300	\$169.079	\$0.000	\$252.378
	9/12/2017										
110		0.00	0.00	2.56	2.56	1.00	\$0.000	\$55.077	\$111.793	\$0.000	\$166.869
110		0.00	0.00	4.87	4.87	1.00	\$0.000	\$104.735	\$212.588	\$0.000	\$317.323
	9/14/2017										
180		0.00	0.00	3.86	3.86	1.00	\$0.000	\$82.977	\$168.424	\$0.000	\$251.401
	9/15/2017										
180		0.00	0.00	4.90	4.90	1.00	\$0.000	\$105.350	\$213.836	\$0.000	\$319.186
	9/18/2017										
180		0.00	0.00	4.93	4.93	1.00	\$0.000	\$106.085	\$215.329	\$0.000	\$321.414
Total:		0.00	0.00	34.77	34.77	8.00	\$0.000	\$747.598	\$1,517.450	\$0.000	\$2,265.048

Work Center Powdercoat

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ROQU01												
	9/20/2017											
220		0.00	0.00	2.99	2.99	1.00	\$0.000	\$65.290	\$162.972	\$0.000	\$228.262	
Total:		0.00	0.00	2.99	2.99	1.00	\$0.000	\$65.290	\$162.972	\$0.000	\$228.262	

Work Order ID 165855***165855***

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3272	Rev B								



100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								

110	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
110	Large Fab								
Large Fab	Memo	3.20							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>M136158</u>								
	3-Grind End Plate flush								

x10 S.L. 2017-9-12

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Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/25/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(8) (2)		SEP 18 2017	DAS 24 9-89 PTO
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(8)		17.09.13	PD
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 2.00				LH (8) P		2017-09-14	JSJ JSL

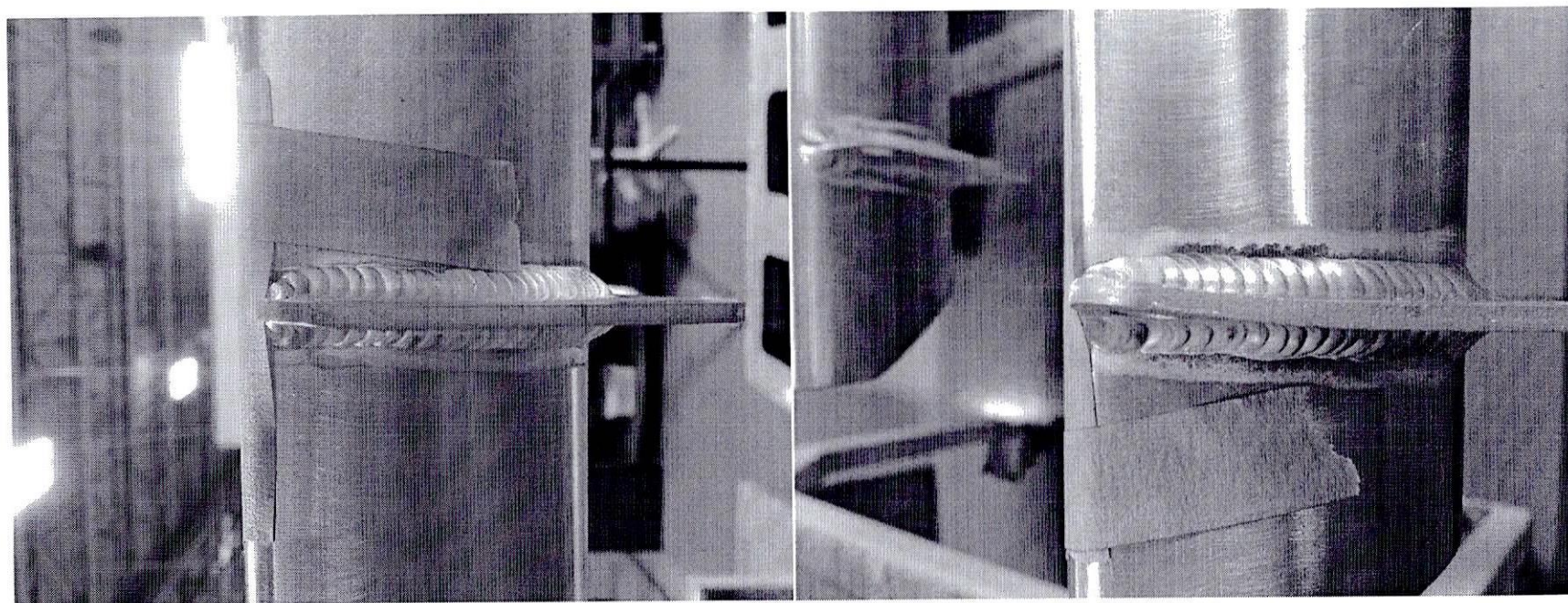
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : <u>17.09.13</u>		Step #: <u>110</u>		QTY Effective : <u>3</u>			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				<u>PD 17.09.13</u> Completed By <u>G.V.</u> Lead hand / Supervisor Approval Verification DAS 24 SEP 18 2017 9-89 QC / QA Coordinator Approval <u>PD 17.09.13</u>			
<u>found at inspection to lugs</u> <u>on two different step where</u> <u>bent (see attach pictures)</u> <u>P.C. handling / operator</u>				<u>Scrap destroy qty 3</u> <u>no replace</u>							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☒ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											



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Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/25/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.10							
Quality Control									
180	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
180	Large Fab								
Large Fab	Memo	2.80							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>M3658</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

80 1708.14 34 0.00

x8 2017.9.18 S.L

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Item ID: D350-591-311 Accept
Revision ID:
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 *10*
Required Date: 9/25/2017 Req'd Qty: 10.00 *10*
Reference:

N900040100 Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				8	SEP 18 2017		DAS 24 9-89
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				8	SEP 18 2017		DAS 24 9-89
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.70				(LH) 8	2017-09-17		DAS 24 9-89 JSL

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M13804</i> Memo START TIME: <i>3:30</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>4:00</i>	0.00 1.70				<i>8</i>	<i>0</i>	<i>17-09-20</i>	<i>38</i>
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M138373</i> Memo	0.00 1.90				<i>(X8)</i>	<i>0</i>	<i>201709/26</i>	<i>3EB</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<i>8</i>		<i>38</i> <i>9-29</i>	<i>SEP 27 2017</i>

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/1/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.10							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.30							
Quality Control									
270	Identify as per dwg & Stock Location: _____	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311 Location : FG084								

DAS 27 9-89
OCT 16 2017

DAS 28 9-89
SEP 22 2017

165855

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 9/25/2017 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

1.00

Quality Control

Picklist Print

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Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-35A

Purchased

No

250

Each

96.0000

2

20

AN3-35A

Bolt

**

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

86

M138170

86

20

SEP 25 2017

DAS
28
9-89

DAS
27
9-89

AN4-13A

Purchased

No

250

Each

344.0000

8

80

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

9

m135470

9

ST344

315

m138170

115

m138326

200

5000662

SEP 25 2017

DAS
28
9-89

DAS
27
9-89

AN5-36A

Purchased

No

250

Each

78.0000

2

20

AN5-36A

Bolt

**

Location

Loc Qty

Loc Code

ST336

78

m137963

50

m138209

28

20

SEP 25 2017

DAS
28
9-89

DAS
27
9-89

Picklist Print

Page 2

Thursday, August 31, 2017 1:27:51 PM

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

D2230-3 Manufactured No 250 Each 272.0000 4 40

D2230-3

Mounting Lug

**

SEP 25 2017

DAS
28
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	4	
109344	4	
ST521	268	
162754	28	
163291	80	
164011	160	

40

D2618 Manufactured No 250 Each 41.0000 2 20

D2618

Bushing

**

SEP 25 2017

DAS
6
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
ST008A	41	
163460	41	

~~1649914~~

165366

D2856-400-720 Manufactured No 250 Each 229.0000 2 20

D2856-400-720

Abrasion Strip 4" X 7.20"

**

DAS
28
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	49	
158146	9	
161232	40	
ST418	180	
165231	180	

20

SEP 25 2017

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Shop Packet Print

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Picklist Print

Thursday, August 31, 2017 1:27:52 PM

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

28.0000

1

10

D3065-041

**

Step Leg Assembly

Location

Loc Qty

Loc Code

WA002

28

B165610

X10 S.L 2017-9-14

162415

2

164384

1

165204

25

D3066-1

Manufactured No

180

Each

54.0000

2

20

D3066-1

**

Spacer

Location

Loc Qty

Loc Code

WA003

54

159117

4

162500

50

X10 S.L 2017-9-14

D3067-1

Manufactured No

110

Each

20.0000

1

10

D3067-1

**

End Plate

Location

Loc Qty

Loc Code

WA003

20

B165725

X6 S.L 2017-9-8

163742

20

X4 S.L 2017-9-8

D3067-1

Manufactured No

180

Each

20.0000

1

10

D3067-1

**

End Plate

Location

Loc Qty

Loc Code

WA003

20

B165725

X10 S.L 2017-9-14

163742

20

Picklist Print

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Page 4

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No 110 Each 21.0000 2 20

D3219-1 ✓

Plate

**

Location

Loc Qty

Loc Code

WA003

21

B165567 x20 S.L 2017.9.8

162382

16

162848

5

D3235-1 Manufactured No 250 Each 83.0000 2 20

D3235-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST522

83

SEP 25 2017

162757

83

20

D3272-1 Manufactured No 110 Each 21.0000 1 10

D3272-1

Step

**

Location

Loc Qty

Loc Code

WA003

21

B165582 → 10

164356

10

164968

11

D3278-041 Manufactured No 250 Each 38.0000 1 10

D3278-041

Support Assembly

**

Location

Loc Qty

Loc Code

ST522

38

~~B165569~~ 10

160701

2

162850

16

164347

20

SEP 25 2017

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Shop Packet Print

Page 4

Picklist Print

Thursday, August 31, 2017 1:27:52 PM

Page 5

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

517.0000

16

160

MS20600-AD4W4

Rivet

B138441

**

x160

S.L 2017-9-4

Location

Loc Qty

Loc Code

ST308

29

M138209

29

WA003

488

M135442

204

M136986

108

M137412

63

M137820

21

M138209

92

MS21042L3

Purchased

No

250

Each

1,327.000

2

20

MS21042L3

Nut

**

DAS
28
9-89

DAS
28
9-89

SEP 25 2017

Location

Loc Qty

Loc Code

FP001

72

m135945

72

GA

336

m134360

102

M136665

234

ST303

919

M126333

16

m138084

14

m138230

500

m138326

389

DAS
27
9-89

20

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Picklist Print

Thursday, August 31, 2017 1:27:52 PM

Page 6

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

2,581.000

8

80

MS21042I 4

Nut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

OVER007

1000

m138170

500

m138230

500

ST303

1571

127376

24

m138084

547

m138326

1000

SEP 25 2017

DAS
27
9-89

80

MS21042L5

Purchased

No

250

Each

519.0000

2

20

MS21042I 5

Nut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

10

m127813

10

ST303

509

125535

4

m137587

5

m137963

200

m138209

200

m138336

100

SEP 25 2017

DAS
27
9-89

20

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Shop Packet Print

Page 6

Picklist Print

Thursday, August 31, 2017 1:27:53 PM

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0363J

Purchased

No

250

Each

1,407.000

4

40

NAS1149D0363.J

**

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

408

m137963

408

ST263

999

126319

16

m138336

983

250

Each

2,738.000

16

160

NAS1149D0463J

Purchased

No

NAS1149D0463.J

**

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

547

M135056

40

M137699

507

Return2017

16

M136665

16

ST263

2175

127693

48

M137988

600

M138084

71

M138230

1456

SEP 22 2017

DAS
28
9-89

SEP 22 2017

DAS
28
9-89

Picklist Print

Thursday, August 31, 2017 1:27:53 PM

Work Order ID: 165855

165855

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/1/2017

Required Date: 9/25/2017

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

1,463.000

4

40

NAS1149D0563.J

**

Washer

DAS
28
9-89

SEP 22 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

36

m135774

36

ST263

1427

m126319

16

m137820

11

m138040

700

m138209

700

40

DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

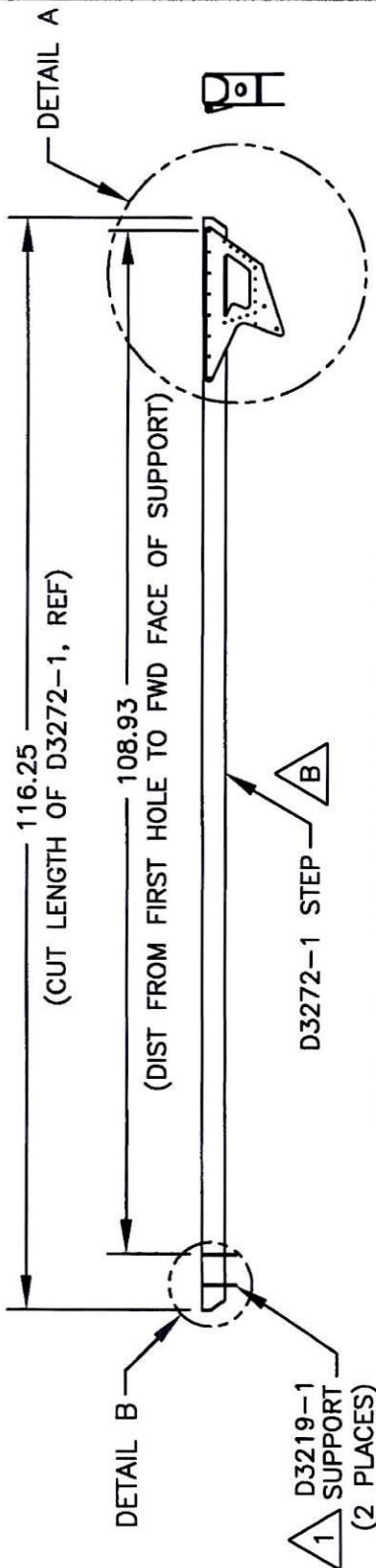
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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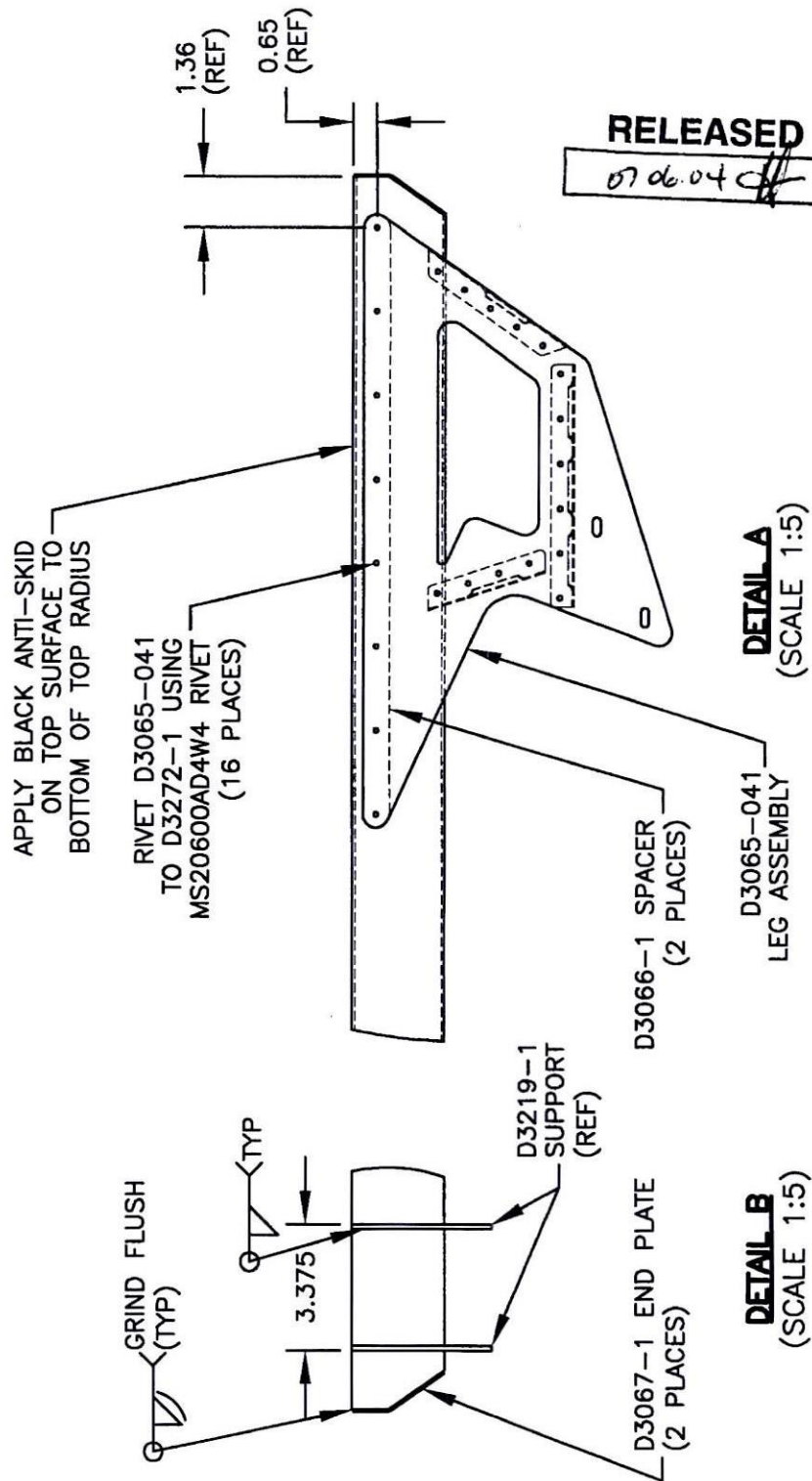
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DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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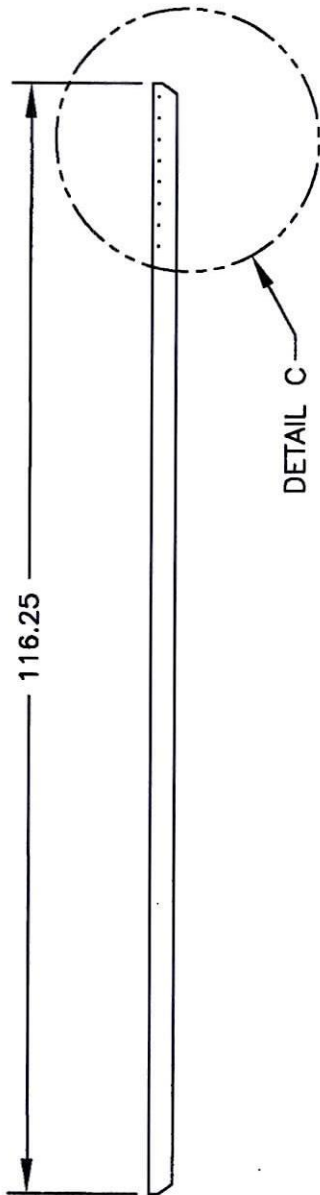
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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

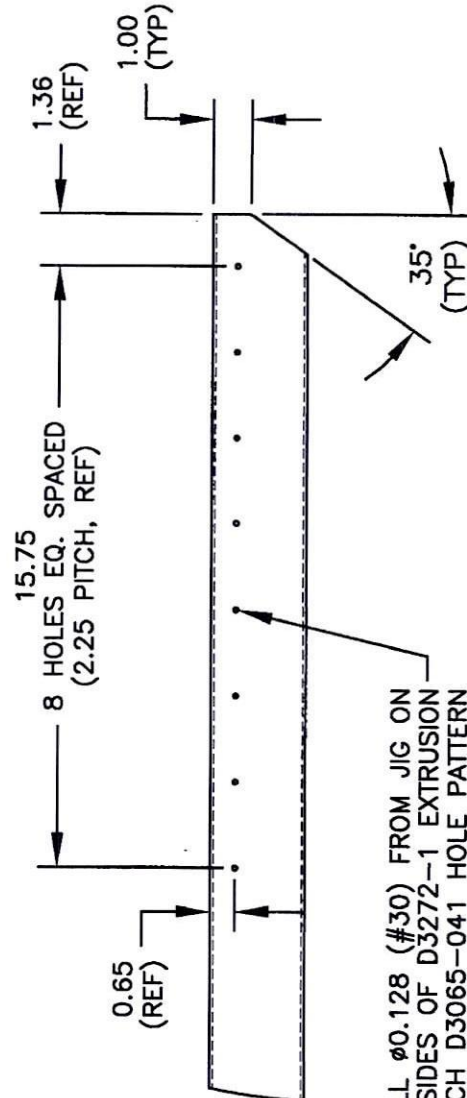
07.06.04 *H*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.